Date:

Wednesday, 30/04/2008 10:23:20 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

S.O. No. :

: 38905 : 12716

Estimate Number

P.O. Number

This Issue : 30/04/2008

: NC

: // : 38183 Type

: SMALL /MED FAB

Part Number

Drawing Name

: D353635

: GASKET

Drawing Number

: D3536 REV A

Project Number

: N/A

Drawing Revision

Material **Due Date**

: 09/05/2008

Qty:

20 Um:

Each

Prsht Rev.

First Issue

Previous Run

Written By Checked & Approved By

Comment

: Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

MNEO60S063 1.0

NEOPRENE SHEET 0.063



Comment: Qty.:

0.6507 sf(s)/Unit **NEOPRENE SHEET 0.063**

Total: 13.0137 sf(s)

Batch: 167.6\$\$





Comment: FI OW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:__ Prog Rev: A



2-Deburr if necessary

3.0

2.0

QC2



B8-S-2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND





5.0 PACKAGING 1 PACKAGING RESOURCE #1



Identify and Stock Location:_



Comment: PACKAGING RESOURCE #1



Dart Aerospace Lt

W/O:				I	V	VORK ORDER CHANG	ES			
DATE	STEP	·	!	PROC	EDURE CI	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		1								
Part No	:		PAR #:		_ Fault Ca	tegory:	NCR: Yes	No DQA :	Date: _	
		ŀ	İ			•	QA: N	C Closed:	Date: _	
NCR:			i	W	ORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP		Description of NC	;		Corrective Action Section		Verification	Approval	Approval
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NOTE: Date & initial all entries

Date:

Wednesday, 30/04/2008 10:23:20 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38905

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



INAL INSPECTION/W/O RELEASE

08/05/05/

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-05

Dart	Aero	ospa	ce Ltd	l

W/O:				V	VORK ORDER CH	ANGES				
DATE	STEP		PR	OCEDURE CI	IANGE	В	у	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	! !	PAR #:	Fault Ca	tegory:	NCR: `	es N	o DQA :	Date:	
						Q	A: N/C	Closed:		
NCR:				WORK OR	DER NON-CONFO	RMANCE (N	ICR)			
DATE	STEP	De	escription of NC Section A	Initial Chief Eng	Corrective Action Action Descrip		gn & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

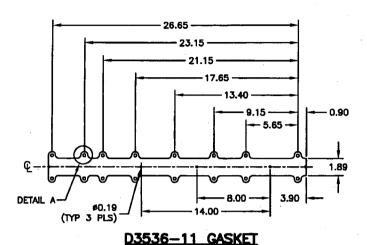
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART AEROSPACE LTD	Work Order:	38905
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

	FIRST	ARTICLE INSF	ECTION	CHECKL	.IST	
	X	First Article	F	Prototyp	e	
Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Neject	Inspection	Comments
23.25	+/-0.030	25.50	~			
19.75	+/-0.030	19.75	يح .			
17.75	+/-0.030	17.75	· · · · · ·			
14.25	+/-0.030	14.25	يتل			
9.50	+/-0.030	9,50	×			
4.75	+/-0.030	4,75	×			
2.00	+/-0.030	2.60	y			
6.00	+/-0.030	6.00	x			
6.75	+/-0.030	625	<u> </u>			
0.30	+/-0.030	.303	*			
0.30	+/-0.030	,363	*			
1.89	+/-0.030	1.897	X			
Ø0.19	+0.005/-0.001		¥			
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easured by:	B.	Audited by:		Pro	totype Approval:	N/A
		Date:	مرحا رحا	→ 	Date:	
Date.	8-2-5	Date.	25/05/0		Date.	18/7

Rev	Date	Change	,	Revised by	Approyed
Α	07.03.14	New Issue	,	KJ/JLM ox	
				171	7,0-7

B.62.12



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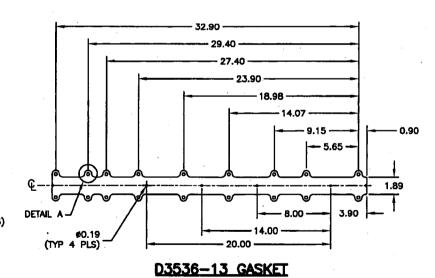
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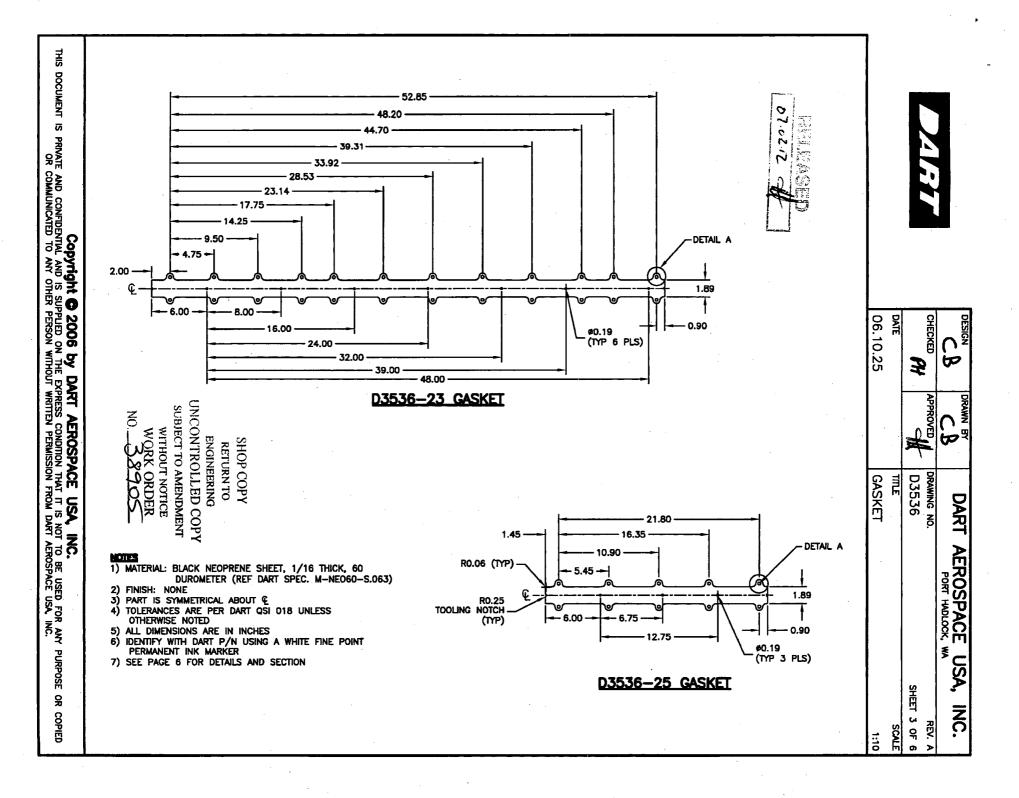
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



CB	CB	DAKI	PORT HADLOCK, WA	* C. C. A.	NC.
	APPROVED /	DRAWING NO.	·		REV. A
W	#	D3536		3HS	SHEET 1 OF 6
DATE		3TML			SCALE
06.10.25		GASKET			1:10
>	06.10.25	06.10.25 NEW ISSUE			



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D3536-31 GASKET

07.02.12 2.00 -6.00 -1.89 6.00 DETAIL A #0.19 (TYP 3 PLS)

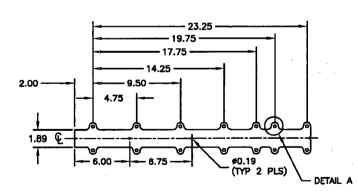
D3536-33 GASKET

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- 2) FINISH: NONE

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- 2) FINSH: NONE
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 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
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D3536-35_GASKET

1:10	GASKET		06.10.25
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SHEET 4 OF 6	D3536		777
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PORT HADLOCK, WA	0743	CB	CB
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3) PART IS SYMMETRICAL ABOUT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2.00 -ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER 1.88 7) SEE PAGE 6 FOR DETAILS AND SECTION #0.19 (TYP 3 PLS) ----- 5.00 → DETAIL A 9.00 28.00 PURPOSE D3536-39 GASKET SHEET 윢 COPIED 5 OF 6 SCALE :: 6

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27.98 2.00 1.88 4.00 -#0.19 (TYP 2 PLS) 3.90 DETAIL A

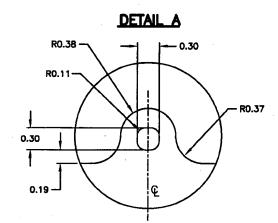
D3536-41 GASKET

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- NOTES

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 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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